

Date: Monday, 5/1/2006 3:57:41 PM
 User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : 206L /407 STEP ASSY, LH
 Job Number : 26879A
 Estimate Number : 11702
 P.O. Number : N/A Part Number : D2724041
 This Issue : 5/1/2006 S.O. No. : N/A Drawing Number : D2724 REV C
 Prsht Rev. : NC Project Number : N/A
 First Issue : N/A Type : LARGE FAB ASSY Drawing Revision : C
 Previous Run : 26346A Material : N/A
 Written By : See Comment Below Due Date : 5/22/2006 Qty: 3 Um: Each
 Checked & Approved By : 06.05.02
 Comment : Est Rev:E As Per Ecn 766 06-01-06 JLM

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 D2622120C Extrusion



Comment: Qty.: 1.0000 Each(s)/Unit Total : 3.0000 Each(s)

Qty Part # Description Batch:

1 D2622-120C Extrusion

B24563

FF

06.05.11

3

Check Material for any Dents or Defects

2.0 LARGE FAB 1 LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

Cut D2724-1 using D2622 extrusion as per Dwg D2724

Deburr and bevel ends for welding

FF

06.05.11

3

3.0 D2734 206 Step Endplate



Comment: Qty.: 2.0000 Each(s)/Unit Total : 6.0000 Each(s)

206 Step Endplate

Pick:

Qty Part Number Description Batch

2 D2734 End Cap

B24402

FF 06.05.12

3

4.0 D34581 PLATE



Comment: Qty.: 2.0000 Each(s)/Unit Total : 6.0000 Each(s)

Pick:

Qty Part Number Description Batch

2 D3458-1 Plate

B24402 B26779 = 2

B26778 = 4

FF 06.05.13

3

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action		Section B		Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date				

NOTE: Date & initial all entries

Date: Monday, 5/1/2006 3:57:41 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 206L /407 STEP ASSY, LH

Job Number: 26879A

Part Number: D2724041

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

D34583

PLATE



Comment: Qty.: 2.0000 Each(s)/Unit Total : 6.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

2 D3458-3

Plate

326779 = 6

PE. 06.05.13

3

6.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

Weld end cap and lugs as per Dwg D2724 using Jig DT followed by Jig

DT (One End Only)

M19173

A/R AL ROD Batch: M15689

Grind end cap welds flush

PE. 06.05.18

3

7.0

QC5/9

WELD INSPECTION



Comment: WELD INSPECTION

PE. 06/05/18 (3)

8.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

PE. 06.05.18

3

9.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

PE. 06.05.18

3

10.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

Inspect for foreign object per QSI 024

Weld Remaining end cap as per Dwg D2724 using Jig DT followed by Jig

DT

A/R AL ROD Batch: M19173

PE. 06.05.23

PE. 06.05.23

3

3

PTO
9

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
06-05-23	10 b	weldless grind end cap flush		lt	06-05-23	3		

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: ☒ Date: 06/06/02

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action		Section B		Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng		Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 5/1/2006 3:57:41 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 206L /407 STEP ASSY, LH

Job Number: 26879A

Part Number: D2724041

Job Number:



Seq. #:

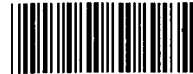
Machine Or Operation:

Description :

11.0

QC5/9

WELD INSPECTION



(3)

Comment: WELD INSPECTION

PD 06-05-23

12.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Touch up Alodine

DL 06/05/23 (3)

13.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

a.m 06-05-26 (3)

14.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

15.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: Wing Walk as per Dwg D2724 and QSI 005 4.4

a.m 06-05-29 (3)

16.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

DL 06/05/30 (3)

17.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

N/A 06/06/01

18.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

06/06/02 (3)

Job Completion



W. J. J. 06/06/02

W/O:		WORK ORDER CHANGES							
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action		Section B		Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date				

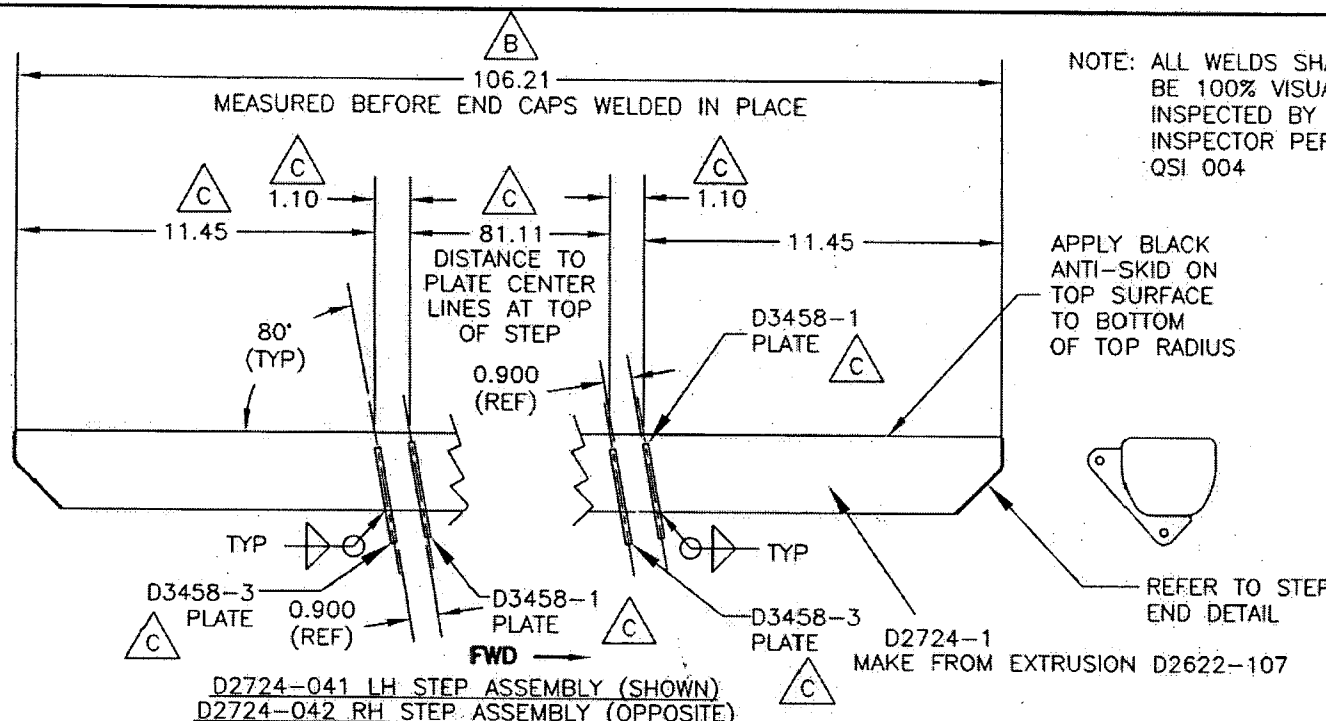
NOTE: Date & initial all entries

DART

RELEASED
05.11.14

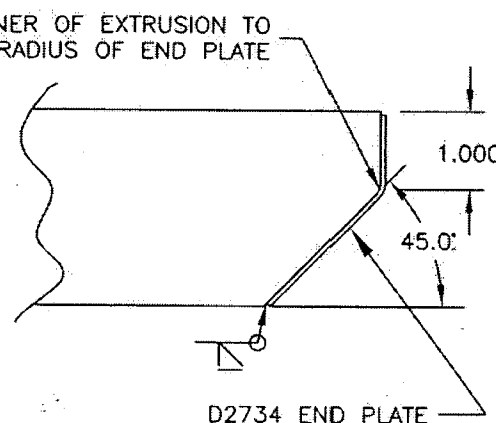
DESIGN	DRAWN BY	DART AEROSPACE USA, INC.	REV. C
KE	PH	PORT HADLOCK, WA	
CHECKED	APPROVED	DRAWING NO.	SHEET 1 OF 1
05.09.19	05.09.19	D2724	
DATE	TITLE	206L/407 STEP ASSEMBLY	SCALE
		NEW ISSUE	NIS
		UPDATED WELD DETAIL	
		REVISED TOLERANCES	
		RE-DESIGN, ADD D3458-1/-3	

NOTE: ALL WELDS SHALL
BE 100% VISUALLY
INSPECTED BY A QUALIFIED
INSPECTOR PER DART
QSI 004



D2721-041/-042 STEP ASSEMBLY PARTS LIST

QTY	QTY	PART NUMBER	DESCRIPTION
-041	-042		
X		D2724-041	LH STEP ASSEMBLY
	X	D2724-042	RH STEP ASSEMBLY
1	1	D2622-107	EXTRUSION
2	2	D2734	END PLATE
2	2	D3458-1	PLATE
2	2	D3458-3	PLATE



TYPICAL STEP END DETAIL
NOT TO SCALE

D2724-041/-042 STEP ASSEMBLY

MAKE FROM EXTRUSION D2622

WELD PER DART QSI 004

FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1

POWDER COAT ASSEMBLY WHITE (4.3.5.1) PER DART QSI 005 4.3

APPLY BLACK ANTI-SKID PAINT PER DART QSI 005 4.4

- ALL DIMENSIONS ARE IN INCHES
- ALL TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

Copyright © 2005 by DART Aerospace USA, Inc.
THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE (S) COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.

ENGINEERING
WITHOUT NOTICE
SUBJECT TO AMENDMENT

NO. 26879A

W/O:		WORK ORDER CHANGES							
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action		Section B		Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng		Sign & Date			

NOTE: Date & initial all entries